

Work Order ID 83412

April-18-12 8:08:58 AM

83412

Page 1

Item ID: D2744

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Cap

Stop ***NS2***

Start Date: 18/04/2012 Start Qty: 30.00

30

Cust Item ID:

Required Date: 02/05/2012 Req'd Qty: 30.00

30

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/04/18

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2744

Rev C

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2744

5052.080

Dwg Rev: C

Prog Rev: C

2-Deburr if necessary

31

32

Ø

Jm / 12-4-29

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

31

32

Ø

Jm / 12-4-29

120

0.00

120

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

50264130

cut

(31)

Ø

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Start Date: 18/04/2012 Start Qty: 30.00

30

Cust Item ID:

Required Date: 02/05/2012 Req'd Qty: 30.00

30

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location: *BALCLAY* 0.00

130

Packaging

Memo

0.00

Packaging

STOCK IN SKIDTUBE CELL

12/4/30 *(31)*

140

QC21- Final Inspection - Work Order Release 0.00

140

QC

Memo

0.00

Quality Control

12/4/30

mf
12-04-30

W/O:		WORK ORDER CHANGES					
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Picklist Print

April-18-12 8:09:03 AM

Page 1

Work Order ID: 83412

83412

Parent Item: D2744

D2744

Parent Item Name: Cap

Start Date: 18/04/2012

Required Date: 02/05/2012

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP C03.01.17Reformat; Dwg revisedKJ/RF
IPP Rev:D Now on Waterjet 06-06-16 JLM
IPP Rev:E As per Rev C 07-07-28 JLM Verified By:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M5052H32S.080		Purchased	No			100	sf	32.5000	0.1823	5.756842			

M5052H32S 080

**

5052-H32 .080 Sheet

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT022	32.5	
100742	26.5	
100974	4	
19729	2	

100742

J m / mll
12-4-29

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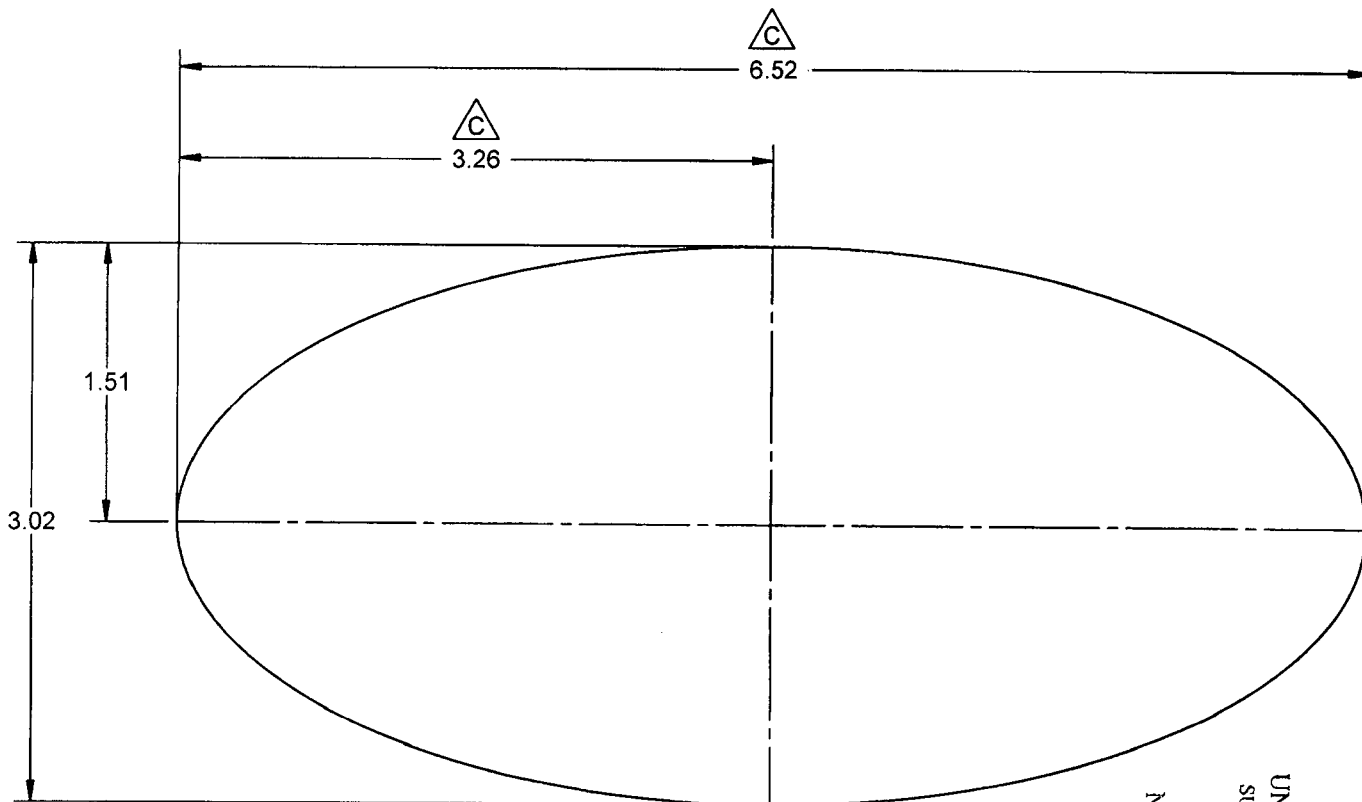
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DESIGN #	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED #	APPROVED #	DRAWING NO. D2744	REV. C SHEET 1 OF 1
DATE 06.10.05		TITLE CAP	SCALE 1:1
REV	DATE	DESCRIPTION	
A	98.04.16	NEW ISSUE	
B	02.12.18	RE-DESIGN	
C	06.10.05	3.26 WAS 3.13; 6.52 WAS 6.27	

RELEASED
07-08-02-#



D2744 CAP

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 83412 MLS
12/04/18

NOTES:

- 1) MATERIAL: ALUMINUM 6061-T6 SHEET 0.080 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF DART SPEC M6061T6S.080)
OR ALUMINUM 5052-H32 SHEET 0.080 THICK PER QQ-A-250/8 OR AMS 4016
(REF DART SPEC M5052H32S.080)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS

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